

Date: Tuesday, 28/10/2008 8:21:53 AM  
User: Linda Lacelle

## Process Sheet

Customer : CU-DAR001 Dart Helicopters Services Drawing Name : BRACKET  
Job Number : 42994  
Estimate Number : 12966  
P.O. Number :  
This Issue : 28/10/2008 S.O. No. :  
Prsht Rev. : NC Part Number : D3637041  
First Issue : / / Type : SMALL /MED FAB Drawing Number : D3637 REV B  
Previous Run : 42822 Project Number : N/A  
Material : B  
Due Date : 04/11/2008 Qty: 3 Um: Each  
Written By :  
Checked & Approved By :  
Comment : Est Rev:A New Issue 07-07-20 JLM Verified By:EC  
Est Rev:B change to REV.B as per dwg 08-02-11 DD verified  
by:ec

## Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 M304S14GA 304SS sheet .080



Comment: Qty.: 0.0945 sf(s)/Unit Total : 0.2835 sf(s)  
304SS .080  
Batch: 109358 HB 8-10-07

2.0 WATER JET FLOW WATER JET



Comment: FLOW WATER JET  
1-Cut as per Dwg D3637  
Dwg Rev: A  
Prog Rev: A

HB 8-10-07

2-Deburr if necessary

HB 8-10-07

3.0 QC2 INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

4.0 QC8 SECOND CHECK



Comment: SECOND CHECK

S 08/10/09 (43)

5.0 BRAKE NC NC BRAKE



Comment: NC BRAKE  
Form as per Dwg D3637

SB 08/11/18

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D3637-041 PAR #: N/A Fault Category: Prod. Sm Med NCR: Yes No DQA: 1A Date: 08.11.20  
 (D350-746-011) Resolution: Scrap Disposition: Scrap QA: N/C Closed: 1A Date: 08/11/20

NCR: <u>42994</u>		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
8/10/20	#20	Three parts scrap. RC made with wrong program. 2 were made <del>with</del> <u>using</u> B D3637-3 program not	AB	Scrap and destroy and Replen Qty @ B# <u>109358</u>	HB 8-10-20	S 08/10/20	B 08/11/20	S 08/10/20
		D3637-1 operator error						

NOTE: Date & initial all entries

Date: Tuesday, 28/10/2008 8:21:53 AM  
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Drawing Name: BRACKET

Job Number: 42994

Part Number: D3637041

Job Number:



Seq. #:	Machine Or Operation:	Description :
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6.0

MS21059L4

Nutplate



Comment: Qty.: 1.0000 Each(s)/Unit Total : 3.0000 Each(s)

Nutplate

BATCH: M 106322

FF 08/11/18

3

7.0

MS20426AD33

Rivet



Comment: Qty.: 2.0000 Each(s)/Unit Total : 6.0000 Each(s)

Rivet

BATCH: M 1563

FF 08/11/18

3

8.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

1- drill holes as per dwg using DT8979

2-C'Sink as per Dwg D3637

3-Install Nut plate as per Dwg D3637

FF 08/11/18

3

9.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

S 08/11/18 (x2)

10.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify with P/N and B/N using a permanent fine point marker, then Stock

Location: 361

S 08/11/18

(3x)

SP

11.0

QC21

FINAL INSPECTION/W/O RELEASE



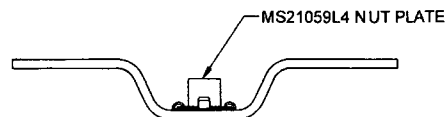
Comment: FINAL INSPECTION/W/O RELEASE

08/11/19

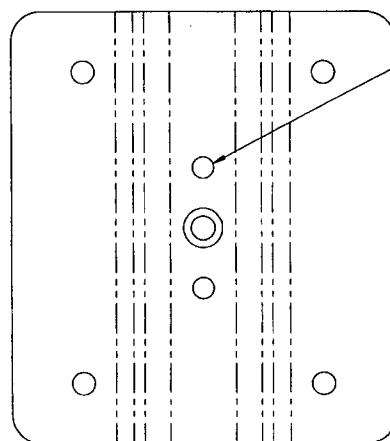
MF 08-11-18

Job Completion



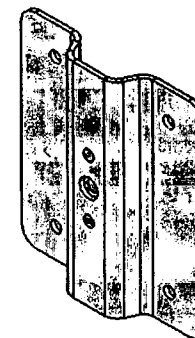


MS21059L4 NUT PLATE



MS20426AD3-3 RIVET  
(2 PLACES)

D3637-1 BRACKET



**D3637-041 BRACKET ASSEMBLY**  
(WAS GENEVA P/N G10602-1)

**D3637-041 PARTS:**

QTY	P/N	DESCRIPTION
X	D3637-041	BRACKET ASSEMBLY
1	D3637-1	BRACKET
1	MS21059L4	NUTPLATE
2	MS20426AD3-3	RIVET

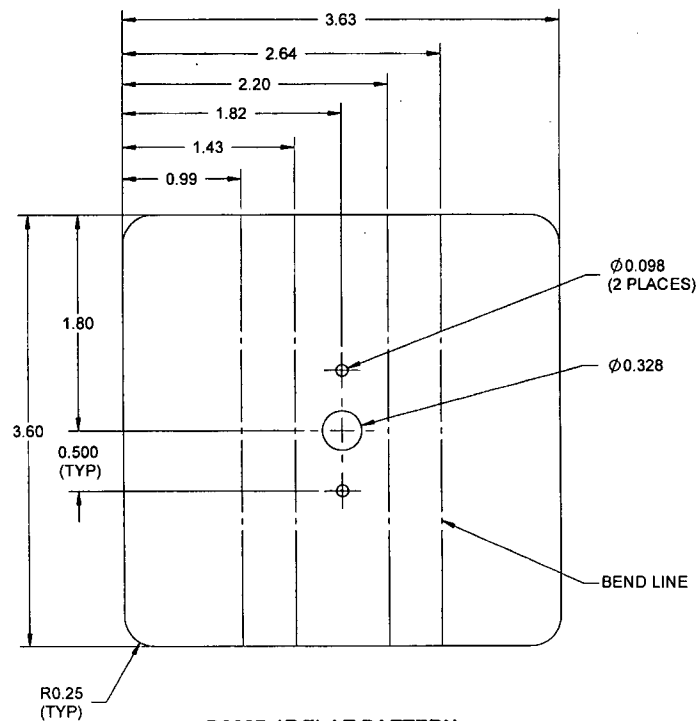
**D3637-041 NOTES:**

- 1) MATERIAL: N/A
- 2) FINISH: N/A
- 3) TOLERANCES: N/A
- 4) UNITS: N/A
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3637-041" USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT: 0.27 lbs

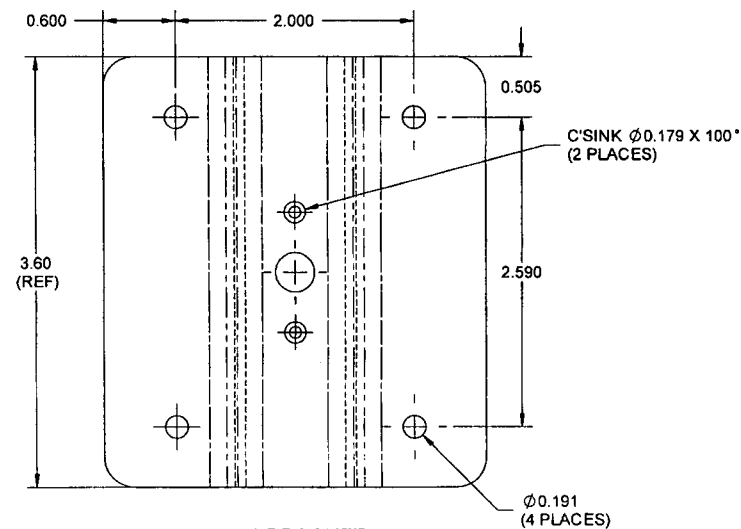
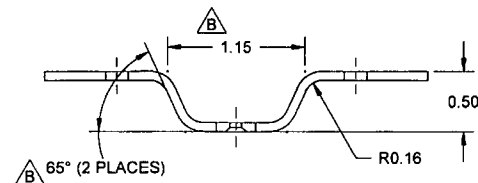
*WFO  
9/2/04*

REV.	DESCRIPTION	BY	DATE
B	FOR D3637-1, 1 15 WAS 1.30 & "REF" REMOVED FROM ANGLE	LE	07.12.18
A	NEW ISSUE; REPLACES G10608, G10602 & G10609	LE	07.07.27
DESIGN	JS	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA DRAWING NO. <b>D3637</b> TITLE <b>BRACKET</b> SCALE 1:1 <small>COPYRIGHT © 2007 BY DART AEROSPACE LTD  THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD</small>	
DRAWN	JS		
CHECKED	JS		
MFG. APPR.	JS		
APPROVED	JS		
DE APPR.	JS		
DATE	07.12.18		

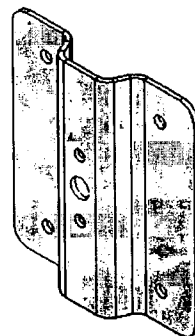
*RELEASED  
26 DEC 05*



**D3637-1F FLAT PATTERN**



**D3637-1 BRACKET  
(WAS GENEVA P/N G10608-1)**



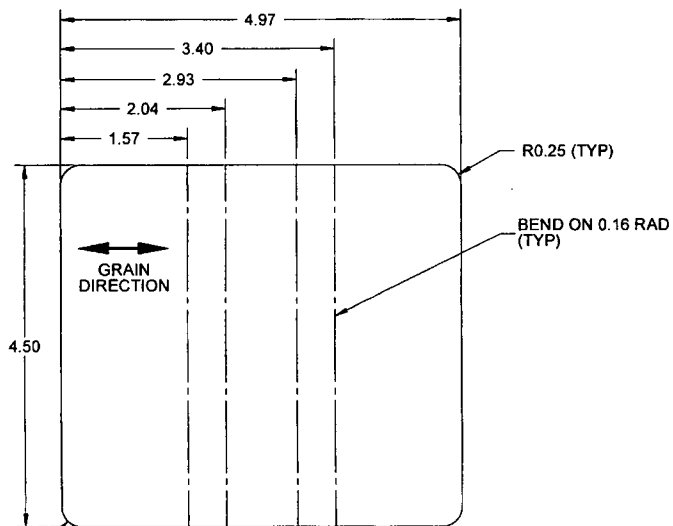
**D3637-1 NOTES:**

- 1) MATERIAL: AISI 304/316 SS SHEET, 14 GAUGE PER MIL-S-5059 (REF DART SPEC M304S14GA)
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 0.26 lbs

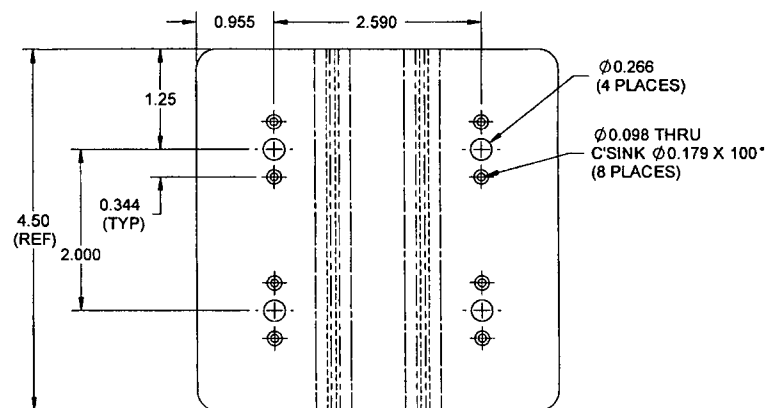
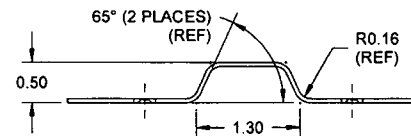
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MFG. APPR.	SO	D3637	SHEET 2 OF 3
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08-23-07

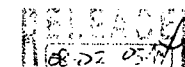
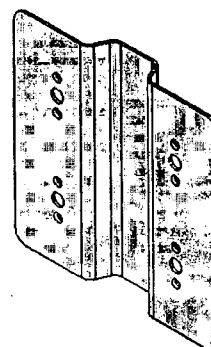
4642994



**D3637-3F FLAT PATTERN**



**D3637-3 BRACKET  
(WAS GENEVA P/N G10609-1)**



- D3637-3 NOTES:**
- 1) MATERIAL: 2024-T3 ALUMINUM 0.050 THICK PER QQ-A-250/4 OR AMS 4037 (REF DART SPEC M2024T3S.050)
  - 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
  - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
  - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
  - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
  - 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3637-3" USING FINE POINT PERMANENT INK MARKER
  - 7) WEIGHT: 0.32 lbs

W642994

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MFG. APPR.	ED	D3637	SHEET 3 OF 3
APPROVED	MT	TITLE	SCALE
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